

Work Order ID 60243

Tuesday, June 29, 2010 2:42:17 PM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop



Start Date: 6/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 10-6-29 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr <i>P61</i>								
D3912	A <i>prelim</i> U								
100	Pick Kit	0.00							



Packaging

Memo

0.00

E/S 10/6/30 ①

110



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

E/S 10/6/30 ①

2- Install helical, spring plunger and spring pin lanyard assy as per dwg
***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L)
IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE
TO ENLARGE WASHER HOLE FOR IT TO FIT***

(P/C)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-06-30	110	See attached parts list (hand written) for correct assy per drawing. Need washer update to G16.	EP	10/06/30	(1)	10/04/23 G16	10/06/30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60243

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Page 2



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Start Date: 6/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC5- Inspect part completeness to step on W/O

0.00

QC



Quality Control

10.06.30

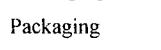
170



Identify as per dwg & Stock Location: _____

0.00

Packaging



Memo

0.00

Packaging



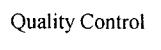
180



QC21- Final Inspection - Work Order Release

0.00

QC



Memo

0.00

Quality Control

A. Rev.B 10.01.23.
test. only.

See P70



POSITIVE RECALL
EFFECTIVE *10/01/23* AUTH *J*
RELEASED *10/01/23* DATE *10/01/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 2:42:16 PM

Page 1

Work Order ID: 60243



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 6/29/2010

Required Date: 7/2/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: new issue DD 09.11.18 verified by:EC
IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C516L WASHER	NAS1149C0532	Purchased	No			100	Each	14.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST347			14						
					111916		14						
ONLY IF NECESSARY, SEE MEMO IN SEQ 110													
MS21209C6-10 Heli Coil, screw locking, red		Purchased	No			100	Each	46.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST304			18						
					108847		16						
					113705		2						
				ST305			28						
					114310		28						
D3912-3 Eyebolt Block		Manufactured	No			100	Each	12.0000	2				
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST096			12						
					59430		12						

EBro/06/30

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 2:42:17 PM

Page 2

Work Order ID: 60243



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 6/29/2010

Required Date: 7/2/2010

Start Qty: 1.00

Required Qty: 1.00

D3912-5

Manufactured

No

100

Each

3.0000

2

Eyebolt Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	3	
58782	3	

D3912-1

Manufactured

No

100

Each

6.0000

1

Eyebolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG096	6	
59441	6	

MS20615-4M20

Purchased

No

100

Each

330.0000

8

RIVET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST323	330	
114808	160	
115054	170	

D3810-1

Manufactured

No

100

Each

18.0000

1

Hand Retractable Spring Plunger

NIA
PA1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST090	18	
54523	1	
57319	17	

D4028-041

Manufactured

No

100

Each

0.0000

1

Spring Pin Lanyard Assembly

NIA
PA1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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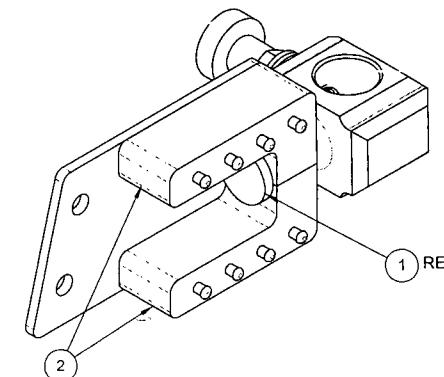
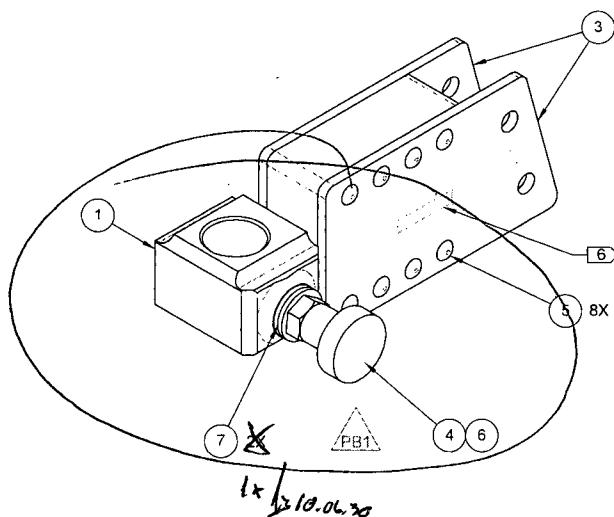
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ITEM	QTY	P/N	DESCRIPTION
	1	X D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	2	NAS1149F0663P	WASHER

1 10.06.20

PB1

PB1



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

60243
X

PB1	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (2X) WASHER NAS1149F0663P ADDED; BOSS ADDED TO D3912-1.	JPH	10.04.21
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. PB1
MFG. APPR.		D3912	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE	10.04.21		

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.61 lbs

D3912-041 EYEBOLT RECEIVER ASSY**PRELIMINARY ISSUE**

10.04.21

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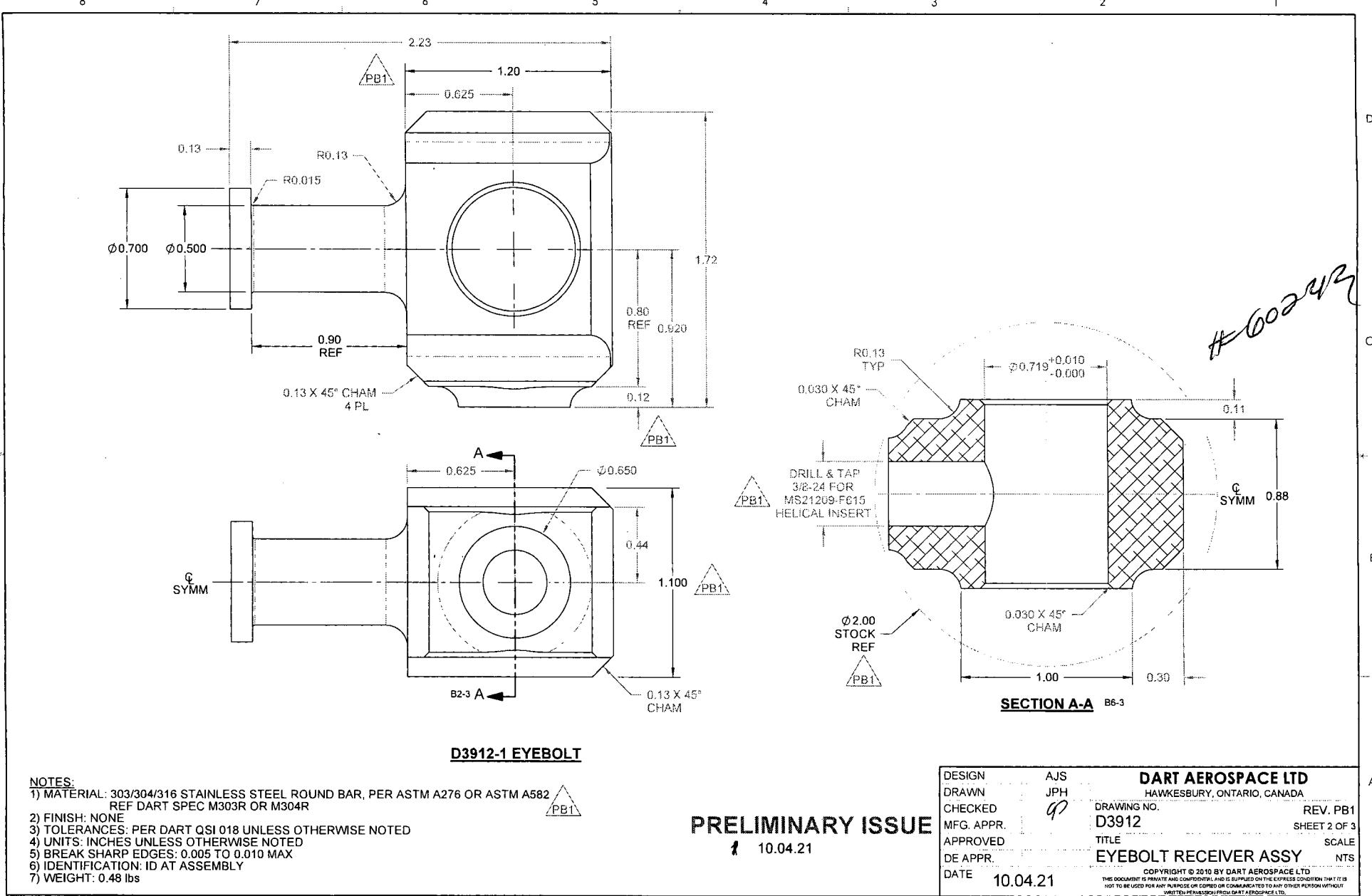
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D

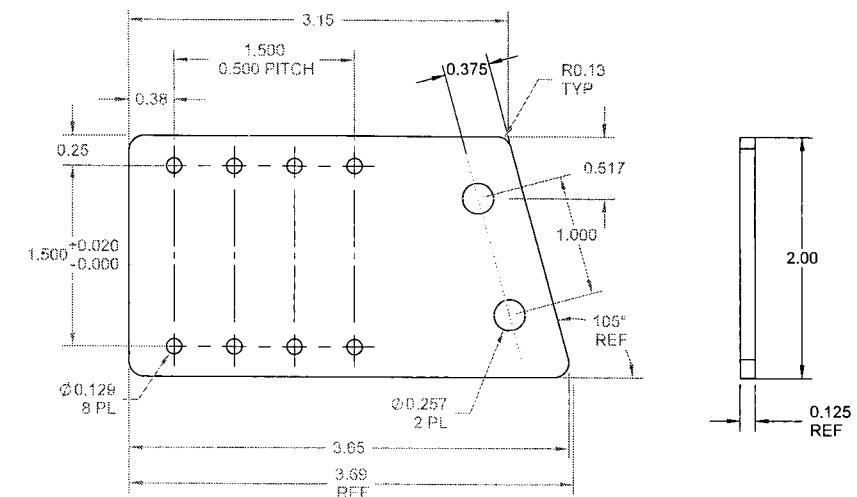
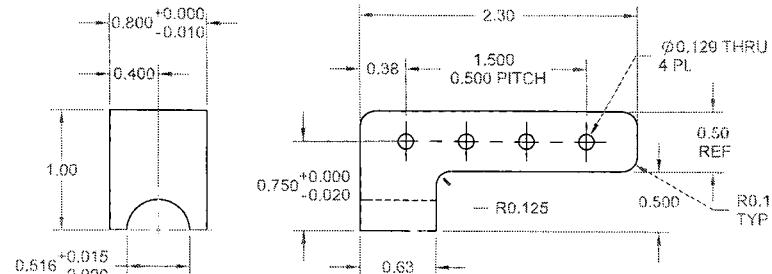
D

C

C

B

B

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

PRELIMINARY ISSUE

10.04.21

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>qP</i>	REV. PB1
MFG. APPR.		DRAWING NO.
APPROVED		D3912
DE APPR.		SHEET 3 OF 3
DATE	10.04.21	SCALE
		NTS
		EYEBOLT RECEIVER ASSY

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1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- Washer : Bath #
AU96C 6/16 M19185 QTY: 2

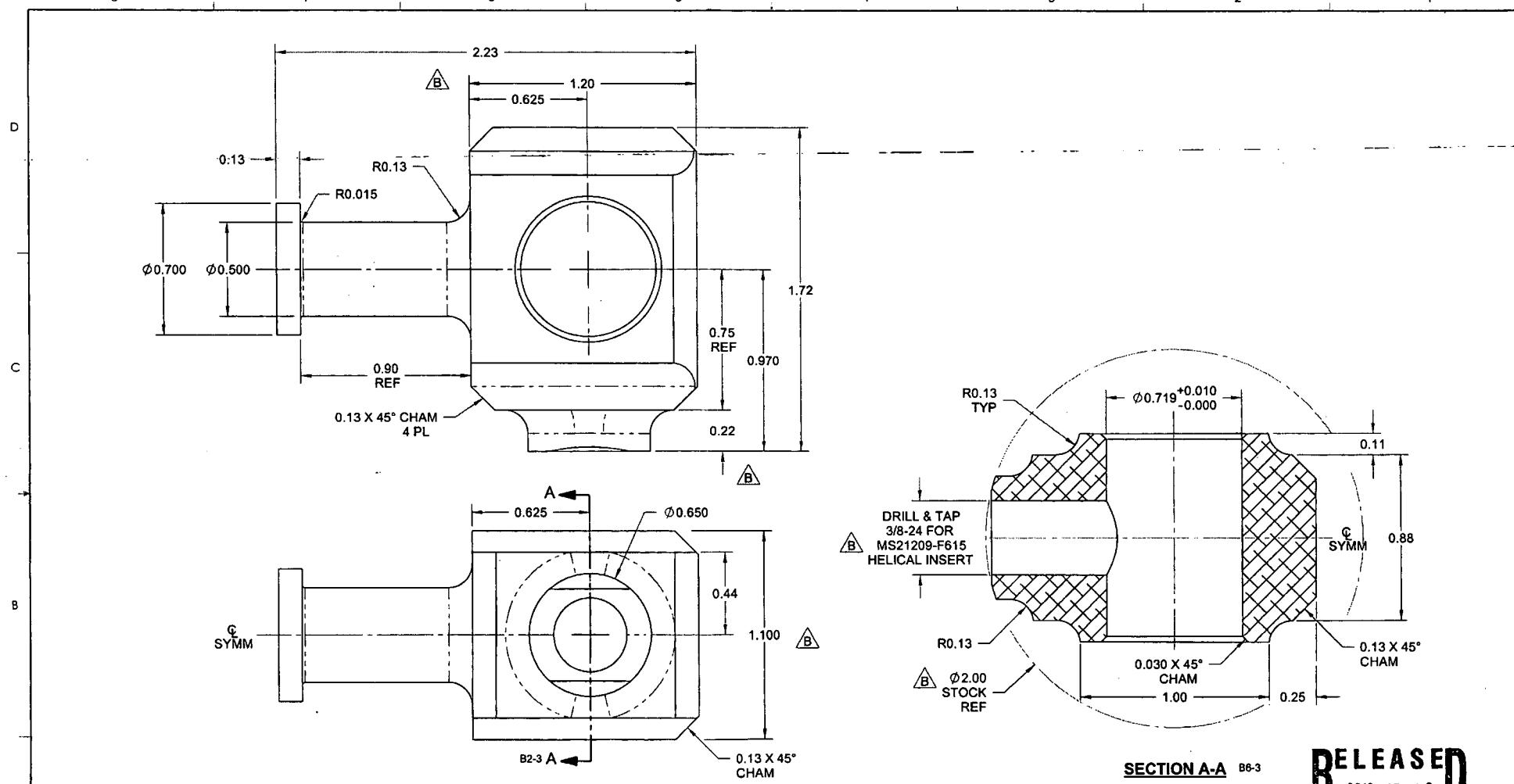
- Hel - coil

MS21209 - FC 15 - M108170 QTY: 1

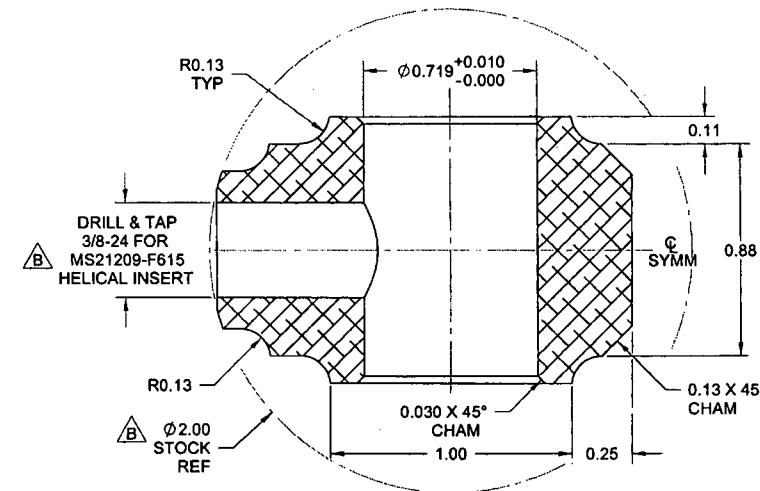
- Spring Plunger

D3801-1 B40736 QTY: 1

8 7 6 5 4 3 2 1

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs

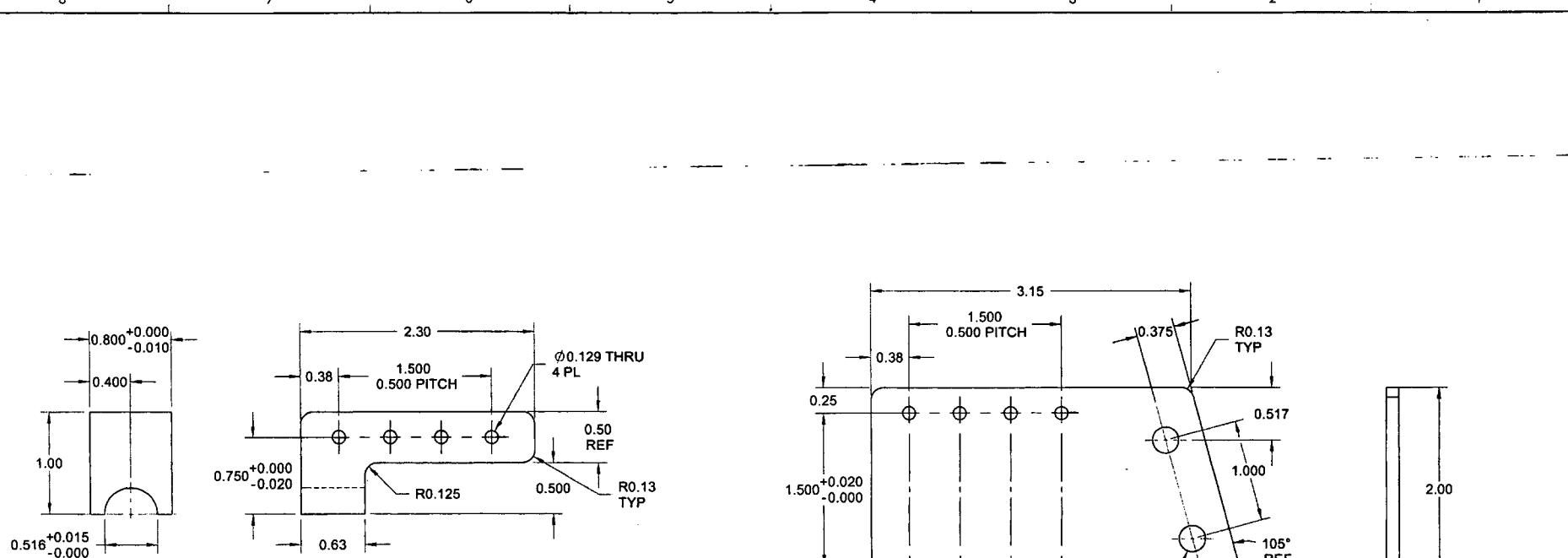


RELEASED
2010-07-16
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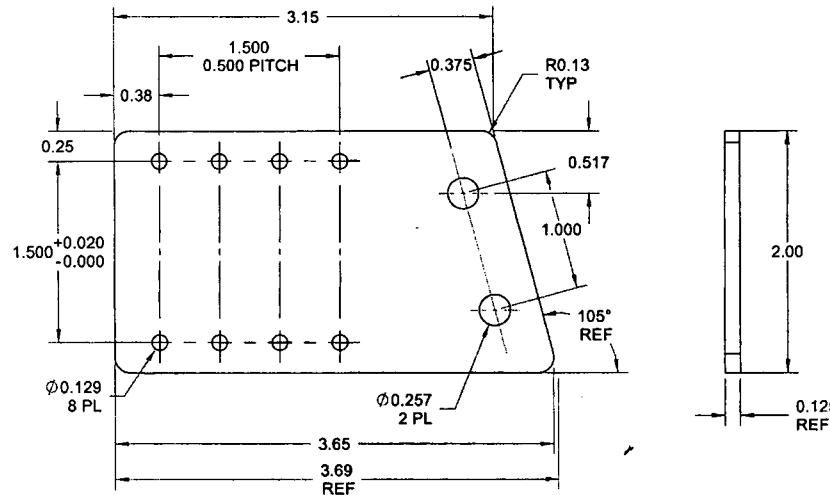
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DRAWN	81	HAWKESBURY, ONTARIO, CANADA
CHECKED	3	DRAWING NO.
MFG. APPR.	7/10	REV. B
APPROVED	10/06/28	D3912
DE APPR.	10/06/28	SHEET 2 OF 3
DATE	10.06.28	TITLE
		SCALE
		EYEBOLT RECEIVER ASSY
		NTS

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8 7 6 5 4 3 2 1



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16
[Signature]

DESIGN	<i>A/S</i>	DART AEROSPACE LTD
DRAWN	<i>SJ</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>B</i>	REV. B
MFG. APPR.	<i>SJ</i>	D3912
APPROVED	<i>SJ</i>	SHEET 3 OF 3
DE APPR.	<i>MJ</i>	TITLE
DATE	10.06.28	SCALE
		NTS

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